

Date: Wednesday, 9/12/2007 12:16:20 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 34633	
Estimate Number : 10937	
P.O. Number : <i>NA</i>	Part Number : D29392
This Issue : 9/12/2007 S.O. No. : <i>NA</i>	Drawing Number : D2939 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NA</i> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 33669	Material : <i>NA</i>
Written By : _____	Due Date : 10/5/2007 Qty: 8 Um: Each
Checked & Approved By : <i>NA 07.09.12</i>	
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC	
Est Rev: C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length

Batch No:

B34643 gmk 07/11/21

(8)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

gmk/SA 07.11.22

(8)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

gmk/SA 07.11.22

(8)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

gmk/SA 07.11.22

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: PD Date: 8/11/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:16:20 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 34633

Part Number: D29392

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8.7 07/11/23 (8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FD 07/11/26 (8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105914

FX 07/14/26 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-L

8X 07/14/27

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/16/27 SD

8X

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/28

Job Completion



U 07-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34633
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.126	.118	.118	.120		
B	0.100	0.140		0.120	.120	.119	.119		
C	0.100	0.140		0.125	.120	.121	.122		
D	0.210	0.230		0.221	.221	.220	.221		
E	1.245	1.255		1.250	1.250	1.249	1.249		
F	1.245	1.255		1.250	1.250	1.250	1.249		
G	2.495	2.505		2.499	2.500	2.499	2.499		
H	0.510	0.515		0.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.578	1.577		
J	2.495	2.505		2.499	2.502	2.501	2.501		
K	0.257	0.262		0.259	.258	.258	.258		
L	0.312	0.317		0.314	.314	.314	.314		
M	0.235	0.240		0.238	.236	.236	.236		
N	0.100	0.140		0.124	.123	.123	.123		
O	0.540	0.560		0.553	.553	.553	.554		
P	0.490	0.510		0.502	.500	.501	.503		
Q	3.715	3.725		3.719	3.720	3.719	3.720		
R	2.720	2.760		2.740	2.745	2.743	2.746		
S	0.240	0.270		0.251	.253	.253	.253		
T	0.100	0.180		0.144	.145	.145	.145		
U	1.625	1.635		1.631	1.630	1.631	1.630		
V	1.362	1.372		1.367	1.367	1.368	1.367		
W	0.316	0.321		0.320	.320	.320	.315		
X	1.250	1.270		1.261	1.259	1.260	1.2605		
Y	1.565	1.585	DT8695 A/B	1.572	1.571	1.572	1.572		
Z	0.178	0.198		0.188	0.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>DMR/SA</i>
Date: <i>07.11.20</i>

Audited by: <i>RF</i>
Date: <i>07/11/23</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	34633
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

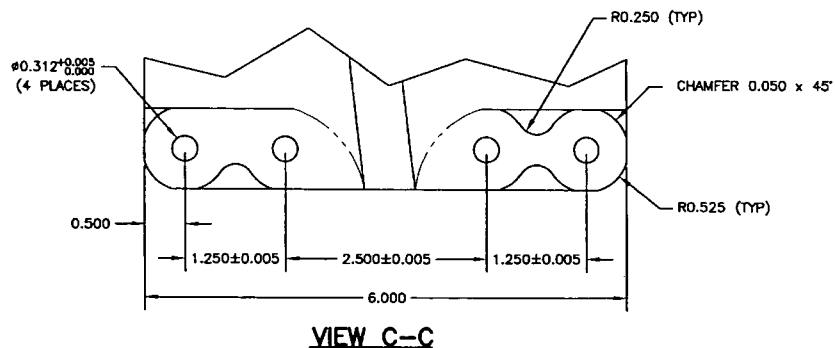
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.118	.120	.119	.120		
B	0.100	0.140		.115	.120	.120	.120		
C	0.100	0.140		.125	.124	.123	.120		
D	0.210	0.230		.221	.220	.219	.220		
E	1.245	1.255		1.258	1.250	1.250	1.250		
F	1.245	1.255		1.245	1.250	1.249	1.250		
G	2.495	2.505		2.500	2.495	2.498	2.499		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.572	1.577	1.578	1.578		
J	2.495	2.505		2.500	2.502	2.501	2.502		
K	0.257	0.262		.258	.255	.257	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.236	.236	.236	.236		
N	0.100	0.140		.123	.122	.123	.122		
O	0.540	0.560		.554	.553	.554	.553		
P	0.490	0.510		.501	.502	.503	.504		
Q	3.715	3.725		3.720	3.720	3.721	3.720		
R	2.720	2.760		2.743	2.744	2.743	2.745		
S	0.240	0.270		.2535	.253	.252	.253		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.627	1.630	1.630		
V	1.362	1.372		1.368	1.369	1.368	1.368		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.2585	1.258	1.259	1.258		
Y	1.565	1.585	DT8695 A/B	1.571	1.570	1.572	1.571		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	07.11.22

Audited by:	RF
Date:	07/11/23

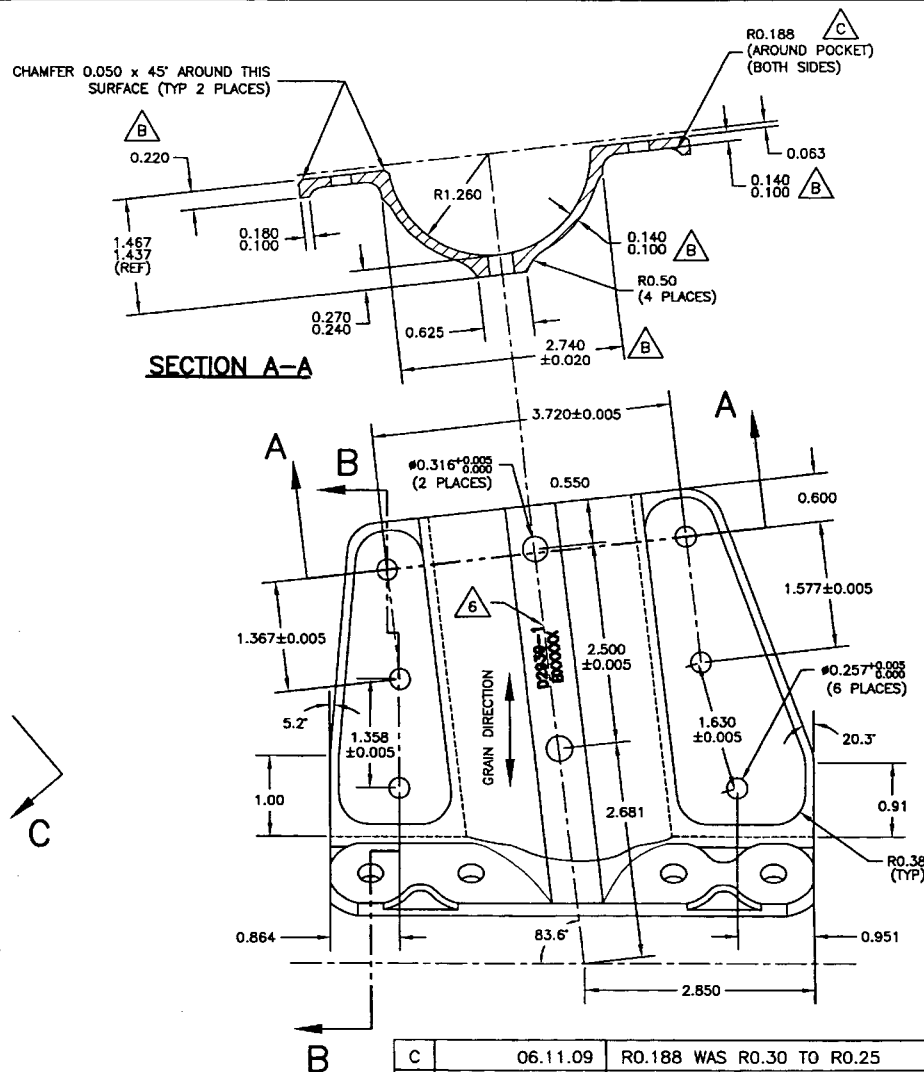
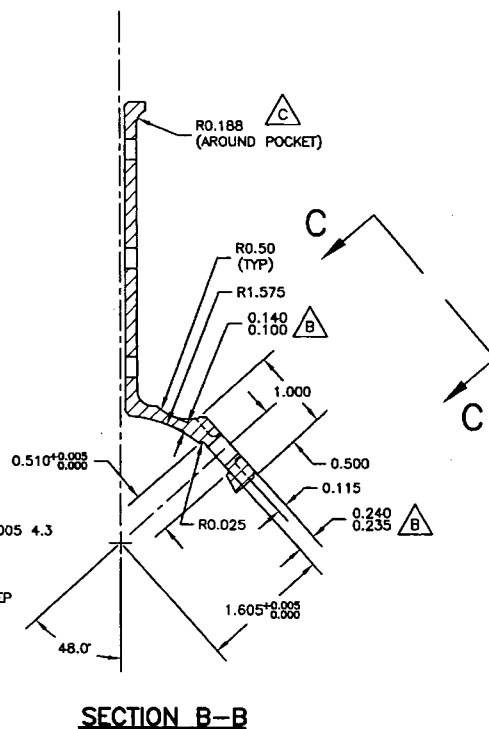
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2939
DATE	TITLE	SADDLE INSIDE
06.11.09		SCALE 2:3

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07.02.12